

Date: Wednesday, 30/01/2008 8:00:11 AM
 User: COSS Admin

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 37113	
Estimate Number : 10980	
P.O. Number :	Part Number : D2808
This Issue : 30/01/2008 S.O. No. :	Drawing Number : D2808 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35330	Material :
Written By : <i>[Signature]</i> 02.01.29	Due Date : 06/02/2008 Qty: 60 Um: Each
Checked & Approved By :	
Comment : Est Rev:D 02.03.07 Now turned in house NG Est Rev:E 07-12-18 RevB as per dwg ECN1048 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6R0625	6061-T6 Round Bar .625"
-----	--------------	-------------------------



(60)

Comment: Qty.: 0.0557 f(s)/Unit Total : 3.3390 f(s)
 6061-T6 Round Bar .625"
 (M6061T6R0625)
 Batch: *M106104*

*H.A**08/01/30*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



(60)

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA205 (Mesure D3387 Bracket .507" Dia for Proper press-fit)

2-Deburr

*H.A / ml**08/01/30*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*H.A / ml**08/01/30*

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK*SG H.A / ml**08/01/30*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



(60)

Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

pl 08-02-01

Date: Wednesday, 30/01/2008 8:00:11 AM
User: COSS Admin

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 37113

Part Number: D2808

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS

08/02/01

(60)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

~~Inspecting~~ ST 48

AS

08/02/01

(60)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/04

(60)

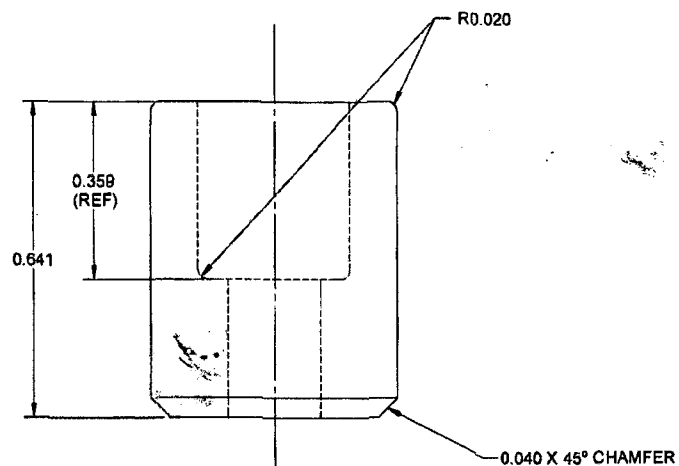
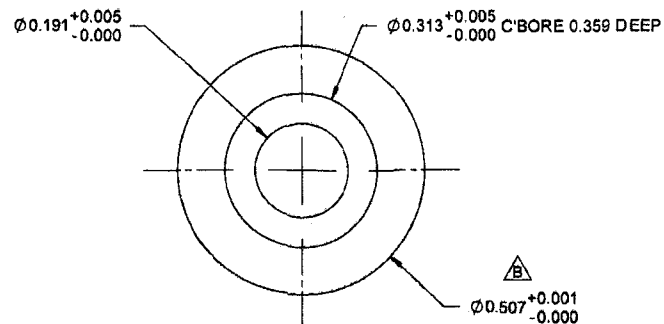
Job Completion



2008/2/04

(60)

W



w/o 37113

RELEASED
DIA 4/13

D2808 SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

B	REMOVE POWDER COAT; Ø0.507 WAS Ø0.500	DC	07.10.12
A	NEW ISSUE	DS	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2808** REV. B
SHEET 1 OF 1
TITLE **SPACER** SCALE 4:1

COPYRIGHT © 2000 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD